

# Work Order ID 51396

August 21, 2009 8:55:23 AM



Page 1

Item ID:	D3601-1	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Radius Block					
Start Date:	20/08/2009	Start Qty:	60.00			
Required Date:	28/08/2009	Req'd Qty:	60.00			
Reference:	<i>09-08-21</i>					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3601	Rev A								
100		0.00							
	SHEAR								
Shear	Memo	0.00							
Shear	blanks 9.00" long +/- 0.030" □ Note: 1 blank makes 8 pieces								
				<i>09/08/21</i>					
				<i>M105061</i>					
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA682 Rev: <u>4A</u> & Dwg D3601 Rev: <u>A</u>								
				<i>09/08/23</i>					
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
				<i>09/08/23</i>					

# Work Order ID 51396

August 21, 2009 8:55:24 AM



Page 2

Item ID: D3601-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Radius Block

Start Date: 20/08/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 60.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

HL 09/08/24

Memo

0.00

140



Small Fab

Small Fab

Small Fab

Memo

Tumble ☐ Deburr any rough edges after tumbling

0.00

0.00

M-L 09/09/01

120X

HB 9-9-2

128

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

mo 09/09/08

X120

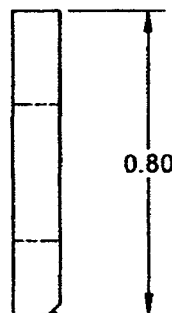
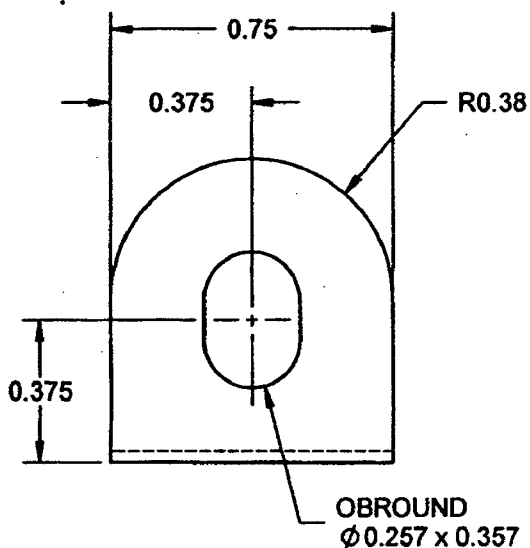
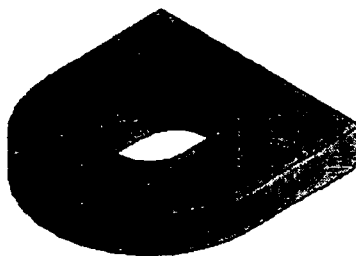


**DART**

DESIGN CB	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3601	REV. A SHEET 1 OF 1
DATE 07.02.13		TITLE RADIUS BLOCK SCALE 2:1	
REV A	DATE 07.02.13	DESCRIPTION NEW ISSUE	

**RELEASED**

07.03.08



CHAMFER 0.05 x 45° OR  
FILLET R 0.05  
0.03

**D3601-1 RADIUS BLOCK****NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.125) OR ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX

**COPYRIGHT © 2007 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

#51396

Status	Item ID	Rev	Name	Start Date	Quantity	UOM	Drop Date	Secrap	ip	Quam	meind	N	C	ILCX	I	Sortme	Offse	in	Ty1	Per	Cch	to	lore	Ce	Last	Id	Da
<input checked="" type="checkbox"/>	M5052H32B0.125X00.75		5052-H32 Bar .12...	09/02/2009	0.0...	f		100	5	0.0...					0		0	M...							09/...	0...	

*mb061T6B00750 x 00.125*  
*Jul/09-09*

*x 7,999*